

5/13

DART AEROSPACE LTD	Work Order:	22513 A
Description: Bracket Assembly	Part Number:	D2803-041
Dwg: D2803 Rev. B	Qty:	5 20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required	PA	05.02.23	20																				
2	GA	Press D2805-1 into arm as per Dwg D2803 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2803-1</td><td>Bracket</td><td>B 22523 A</td></tr><tr><td>1</td><td>D2805-1</td><td>Stop</td><td>B 22522</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>B 22529</td></tr></table>	Qty	Part Number	Description	Batch	1	D2803-1	Bracket	B 22523 A	1	D2805-1	Stop	B 22522	1	D2809	Bushing	B 22529	SB	05/03/28	20				
Qty	Part Number	Description	Batch																						
1	D2803-1	Bracket	B 22523 A																						
1	D2805-1	Stop	B 22522																						
1	D2809	Bushing	B 22529																						
3	QC5	Inspect work to Step 2	Z	05.03.28	20																				
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	M	05.03.29	20																				
5	QC3	Inspect Powder Coat	SB	05/03/31	5																				
6	GA	Press D2809 into arm as per Dwg D2803	SB	05/03/31	5																				
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt</td><td>M 17185</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3)</td><td>M 17187</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td>M 17187</td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td>M 16863</td></tr></table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt	M 17185	2	MS21042L3	Nut (or -3)	M 17187	4	NAS1515H3	Washer	M 17187	A/R	LPS-3	Corrosion Spray	M 16863	SB	05/03/31	5
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt	M 17185																						
2	MS21042L3	Nut (or -3)	M 17187																						
4	NAS1515H3	Washer	M 17187																						
A/R	LPS-3	Corrosion Spray	M 16863																						
8	GA	Assemble as per Dwg D2803.	SB	05/03/31	5																				
9	QC5	Inspect work to Step 8	AB	05.03.31	5																				
10	ST	Identify and Stock	SB	05/03/31	5																				
11	AC	Cost / part: 75.98	545	05.04.01	5																				
12	DC	Close W/O 75.98 Inspect Level 21	PA	05.04.05	5																				

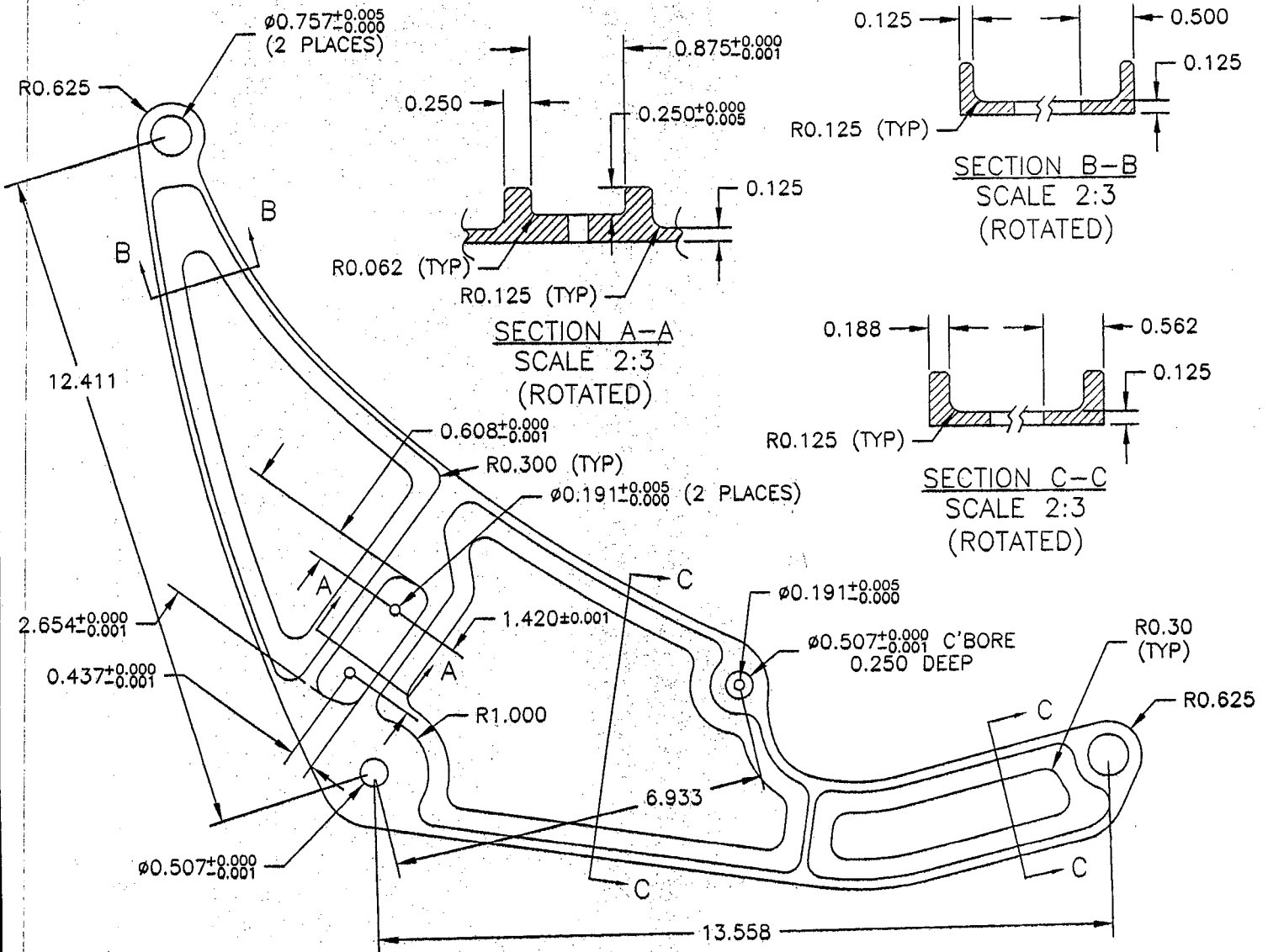
Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	

RELEASED
05/05/2023



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDprt"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

NO. 22513

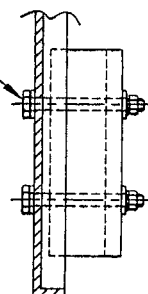
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION D-D
SCALE 1:3
(ROTATED)

USE D2803-1 FOR D2803-041/-043
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041
USE D2805-2 FOR D2803-042
USE D2805-3 FOR D2803-043
USE D2805-4 FOR D2803-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT

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WORK ORDER

RELEASED NO. 22513

05-03-11 *[Signature]*

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
03:39 pm

Work Order No : 0022513
Project Name : D2803-041
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D2803-041
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 02-22-05
Est Finish Date : 03-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00